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D2721-042
Job Sheet 206267



Part No: D2721-042

Job Qty: 7 pcs

Part Name: 206B Step Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/28/20

Job Tracking No:

Due Date: 3/12/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP Rev:F As Per Ecn 766 06-01-06 JLM IPP Rev:G add wing walk DD 10.02.24 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	7 pcs	3/12/20		0.00	1.75	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		CC
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		MAC
							Large Fab - 12		
110	Large Fab - Steps - 2 - B4B	7	3/12/20		0.00	14.51	Large Fab - 1 - B4B		
							Large Fab - 10 - B4B		
							Large Fab - 2 - B4B		
							Large Fab - 3 - B4B		
							Large Fab - 4 - B4B		
							Large Fab - 5 - B4B		
							Large Fab - 6 - B4B		
							Large Fab - 7 - B4B		
							Large Fab - 8 - B4B		
							Large Fab - 9 - B4B		
							Large Fab - 11 - B4B (Various)		
							Large Fab - 12 - B4B		
120	QC 9	7 pcs	3/12/20		0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		DAS
							QC 9 - 50		43
							QC 9 - 9		9-89



Container No: S254174



Part: D2721-042

Job No: 206267

Serial No/Batch: S254174

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 02/10/20

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7 pcs	3/12/20	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	DAS
			QC 5 - 43	43
			QC 5 - 49	9-89
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
140 Handfinish - 1-1 Chemical-B4B 7 pcs	3/12/20	0.00 1.65	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	4 MAR 10 2020
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	
			Handfinish - 1 - 22 - B4B	
150 QC 3 QC 7 7 pcs	3/12/20	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	

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					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
200	Powdercoat - 1 White GI(A)- B4B	7 pcs	3/12/20	0.00 1.01	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	00-03-12
					Powdercoat - 4 - B4B	
210	QC 3	7 pcs	3/12/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	BEB 20-03-12
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
					QC 3 - 43	
					QC 3 - 24	
					QC 3 - 61	
					QC 3 - 81	
					QC 3 - 82	
220	Handfinish - 3-1- WingWalk- B4B	7 pcs	3/12/20	0.00 1.65	Handfinish - 3 - 1 - B4B	
					Handfinish - 3 - 2 - B4B	BEB 24-03-12
					Handfinish - 3 - 3 - B4B	
					Handfinish - 3 - 4 - B4B	
					Handfinish - 3 - 5 - B4B	
230	QC 3	7 pcs	3/12/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	DAS
					QC 3 - 41	81
					QC 3 - 51	9-89
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	

DAS
59
9-89

240 Packaging 3-1 - Stock - B4B	7 pcs	3/12/20	0.00 0.00	QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	DAS
				Packaging 3 - 25 - B4B	72
				Packaging 3 - 26 - B4B	9-89
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
250 QC 21 - SA	7 pcs	3/12/20	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-89 MAR 13 2020

Part Op 100 - Fabricate per Drwg - Cut D2721-2 using D2622 extrusion as per Dwg D2721 Deburr and bevel ends for welding
 Descriptions: DRILL VENT HOLE AS PER SECTION A-A
 110 - Fabricate per Drwg - Weld end cap (One End Only) and lugs as per Dwg D2721 using Jig DT10235 A followed by Jig DT10235B A/R AL Rod Batch: _____ Grind end cap welds flush
 120 - QC9- Inspect visual per QSI004- Fusion Welds
 130 - QC5- Inspect part completeness to step on W/O
 140 - Chemical Conversion Coat per QSI005 4.1)
 150 - QC3- Inspect Part Finish
 160 - Large Fab - Inspect for foreign object per QSI 024 Weld Remaining end cap as per Dwg D2721 BLOCK VENT HOLE USING RIVET AS PER DWG A/R AL Rod Batch: _____ Grind End Cap Welds Flush
 170 - QC9- Inspect visual per QSI004- Fusion Welds
 180 - QC5- Inspect part completeness to step on W/O
 190 - Chemical Conversion Coat per QSI005 4.1
 200 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum - START TIME: 150 OVEN TEMPERATURE: 375
 FINISH TIME: 205
 210 - QC3- Inspect Part Finish
 220 - Wing Walk as per dwg QSI005 4.4 Batch _____

230 - QC3- Inspect Part Finish

240 - Identify as per dwg & Stock Location: _____

250 - QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	7 pcs (1 ea)	100-Large Fab - Steps - 1	⑦ 524 3427
D2734	Step End Plate	7 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5259367 ✓
D3461-1	Mounting Plate	7 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5252981 ✓
D3461-3	Mounting Plate	7 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5253003 ✓
D3461-5	Mounting Plate	7 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	142 383 ✓
D3461-7	Mounting Plate	7 pcs (1 ea)	110-Large Fab - Steps - 2 - B4B	5253079 ✓
MS20601-AD4W2	Rivet	7 Ea (1 ea)	110-Large Fab - Steps - 2 - B4B	5228422 ✓
D2734	Step End Plate	7 pcs (1 ea)	160-Large Fab - Steps - 3 - B4B	5259367 ✓

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	7	133	0
110-Large Fab - Steps - 2 - B4B	D2734	7	34	0
	D3461-1	7	9	0
	D3461-3	7	5	0
	D3461-5	7	19	0
	D3461-7	7	8	0
	MS20601-AD4W2	7	38	0
160-Large Fab - Steps - 3 - B4B	D2734	7	34	0

Part Specifications

Specifications could not be found.

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110 - 014803 ✓



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

MRB (QS1042)

Date: _____

Sequence #: _____

QTY Affected: _____

Description Work Order Deviation

Disposition

Completed By

Lead hand / Supervisor

QC / QA Coordinator

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: